MILITARY SPECIFICATION

HASP, HIGH SECURITY, SHROUDED FOR SHIPBOARD DOORS AND HATCHES USING HIGH AND MEDIUM SECURITY PADLOCK, GENERAL SPECIFICATION FOR

This specification is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers shipboard hasps for high security padlocks.

1.2 Classification. The hasps shall be of the following styles with specific component callouts for each style in accordance with the specification sheet indicated (see table I and 6.2).

Style 1 - Hasp, high security shipboard, arrangement for left-hand or right-hand hinged doors swinging out to open.

Style 2 - Hasp, high security shipboard, arrangement for left-hand or right-hand hinged armored doors swinging out to open.

Style 3 - Hasp, high security shipboard, arrangement for watertight hatches.

Style 4 - Hasp, high security shipboard, arrangement for watertight scuttles.

Style 5 - Hasp, high security shipboard, arrangement for left-hand or right-hand hinged quick acting watertight doors swinging in to open.

Style 6 - Hasp, high security shipboard, arrangement for left-hand or right-hand hinged doors swinging in to open.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 55Z3, Department of the Navy, Washington, DC 20362-5101 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

FSC 5340

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. Unless otherwise specified, the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

QQ-S-766	- Steel Plates, Sheets, and Strip-Corrosion Resisting.
PPP-B-566	- Boxes, Folding, Paperboard.
PPP-B-601	- Boxes, Wood, Cleated-Plywood.
PPP-B-621	- Boxes, Wood, Nailed and Lock-Corner.
PPP-B-676	- Boxes, Setup.

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MIL-C-6021	- Castings, Classification and Inspection of.
MIL-I-6866	- Inspection, Penetrant Method of.
MIL-L-10547	- Liners, Case, and Sheet, Overwrap; Water-Vaporproof or Waterproof, Flexible.
MIL-P-10971	- Pin, Spring, Tubular (Coiled and Slotted).
MIL-H-24653/1	- Hasp, High Security, Shrouded for Shipboard Doors and Hatches Using High and Medium Security Padlock, Style 1.
MIL-H-24653/2	- Hasp, High Security, Shrouded for Shipboard Doors and Hatches Using High and Medium Security Padlock, Style 2.
MIL-H-24653/3	- Hasp, High Security, Shrouded for Shipboard Doors and Hatches Using High and Medium Security Padlock, Style 3.
MIL-H-24653/4	- Hasp, High Security, Shrouded for Shipboard Doors and Hatches Using High and Medium Security Padlock, Style 4.
MIL-H-24653/5	- Hasp, High Security, Shrouded for Shipboard Doors and Hatches Using High and Medium Security Padlock, Style 5.
MIL-H-24653/6	- Hasp, High Security, Shrouded for Shipboard Doors and Hatches Using High and Medium Security Padlock, Style 6.
MIL-E-22200/2C	- Electrodes, Welding, Covered (Austenitic Chromium-Nickel Steel).

STANDARDS

FEDERAL

FED-STD-66	- Steel: Chemical Composition and Hardenability.

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-129 - Marking for Shipment and Storage.

2.1.2 Government drawing. The following Government drawing forms a part of this specification to the extent specified herein.

DRAWING

NAVAL SEA SYSTEMS COMMAND (NAVSEA)
53711-5532337 - High Security Hasp, Shipboard, Pictorial and Parts List.

(Copies of specifications, standards and drawings required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and the supplement thereto, if applicable.

AMERICAN NATIONAL STANDARDS INSTITUTE, INC. (ANSI)
B46.1 - Surface Texture. (DoD adopted)

(Application for copies should be addressed to the American National Standards Institute, Inc., 1430 Broadway, New York, NY 10018.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)
A 36 - Structural Steel. (DoD adopted)
A 743 - Castings, Iron-Chromium, Iron-Chromium-Nickel, Nickel-Base, Corrosion-Resistant, for General Application. (DoD adopted)
E 10 - Brinell Hardness of Metallic Materials, Test Method for. (DoD adopted)
E 18 - Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials, Test Methods for. (DoD adopted)

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

AMERICAN WELDING SOCIETY (AWS)
A5.4 - Specification for Covered Corrosion-Resisting Chromium and Chromium-Nickel Steel Welding Electrodes.

(Application for copies should be addressed to the American Welding Society, Inc., 550 NW LeJeune Road, P.O. Box 351040, Miami, FL 33135.)

SOCIETY OF AUTOMOTIVE ENGINEERS (SAE)
AS 3071A - Acceptance Criteria - Magnetic Particle, Fluorescent Penetrant, and Contrast Dye Penetrant Inspection.

(Application for copies should be addressed to the Society of Automotive Engineers, 400 Commonwealth Drive, Warrendale, PA 15096.)

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT
National Motor Freight Classification

(Application for copies should be addressed to the National Motor Freight Traffic Association, Inc., ATA TRAFFIC Dept., 1616 "P" Street, NW, Washington, DC 20036.)

UNIFORM CLASSIFICATION COMMITTEE AGENT
Uniform Freight Classification Ratings, Rules and Regulations

(Application for copies should be addressed to the Uniform Classification Committee Agent, Tariff Publication Officer, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

(Industry association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 Specification sheets. The individual item requirements shall be as specified herein and in accordance with the applicable specification sheet. In the event of any conflict between the requirements of this specification and the specification sheet, the latter shall govern.

3.2 First article. When specified (see 6.2), the contractor shall furnish six complete hasps of the style required for first article inspection and approval (see 4.3 and 6.3). The first article shall consist of samples and shall conform to the requirements of this specification prior to regular production.

3.2.1 Hasp components. For the purpose of this specification, a complete high security hasp style shall be an assembly of the components listed in table I and detailed on figure 1.

TABLE I. Hasp system components by style.

System components															
Style no.	Instal-lation procedure number	Revers-ible cover	Hasp liner	Tang	Shackle pin for 831B lock	Shackle pin for 826C lock	Lock-ing pins	Bolster plate	Z bracket	Hinge assy	Tang bracket	Foam instal-lation jig	Mount-ing plate	Shim plate set	Spacer
1	MIL-H-24653 /1	X	X	X	2	1	2	X				X		X	
2	MIL-H-24653 /2	X	X	X	2	1	2					X		X	X
3	MIL-H-24653 /3	X	X	X	2	1	2	X			X	X			
4	MIL-H-24653 /4	X	X	X	2	1	2	X				X		X	
5	MIL-H-24653 /5	X	X	X	2	1	2		X	X		X	X	X	
6	MIL-H-24653 /6	X	X	X	2	1	2	X		X		X		X	

NOTE: X indicates one each of that part required.

3.3 Materials.

3.3.1 Castings. The castings shall conform to ASTM A 743, grade 304L. Certified metals from reputable alloy manufacturers shall be used for castings, and in no case shall the weight of the production lot exceed the weight of the purchased certified metals.

3.3.2 Foam installation jig. The installation jig shall be composed of polyethylene foam with a density of not less than 1.7 pound per cubic foot (lb/ft^3) or more than 2.0 lb/ft^3 (hot wire cut is permissible).

3.3.3 Bolster and shim plate. Material for bolster and shim plate shall be in accordance with ASTM A 36 steel.

3.3.4 Locking pin. Locking pins shall be composed of carbon steel conforming to any of the steel numbers 1070 through 1095 as specified in FED-STD-66.

3.3.5 Mounting plate. Material for the mounting plate shall be 300 series stainless steel conforming to QQ-S-766.

3.3.6 Recovered materials. Recycled and recovered raw materials should be used to the extent they are normally used in producing certified materials. Recovered/recycled iron, chromium, nickel, and molybdenum may be used in producing the basic alloy which will then be remelted to make the hasps. Sprues, gates, and runners from the casting operation may be cleaned and remelted for production use. Materials shall be as specified herein. Materials used shall be free from defects which would adversely affect the performance of individual components or the overall assembly. None of the above shall be interpreted to mean that the use of scrap 304L or used or rebuilt products will be allowed.

3.4 Mechanical properties.

3.4.1 Hardness.

3.4.1.1 Casting hardness. When tested in accordance with ASTM E 10, hardness of the cast parts shall be not less than Brinell 150.

3.4.1.2 Locking pin hardness. When tested in accordance with ASTM E 18, hardness shall be not less than Rockwell C46 and shall not exceed Rockwell C53.

3.5 Identical items. Complete hasps of the same style furnished under any specific contract shall be in accordance with this specification and shall be physically identical, within tolerances specified (see 3.1). This requirement includes all parts, assemblies, and components.

3.6 Design and construction. The hasps shall conform to the design, details, dimensions, and materials requirements specified herein and on figure 1, and applicable specification sheets.

3.6.1 Fabrication. Fabrication of the hasp shall be as specified on Drawing 53711-5532337.

3.7 Identification marking. Each hasp reversible cover shall be permanently and legibly marked in accordance with the requirements of figure 1.

3.8 Finish. The hasp surfaces shall have a uniform finish for which roughness does not exceed 125 root mean square when measured in accordance with ANSI B46.1.

3.9 Instructions. Installation instructions shall be included with each hasp based on the style of hasp (see table I).

3.10 Workmanship. Castings shall be sound and free from patching, sharp edges, cracks, voids, shrinkage, and any other defect which reduces the castings ability to perform the intended function. Dimensions shall be within tolerance specified herein and on the applicable specification sheets.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.2 Classification of inspection. The inspection requirements specified herein are classified as follows:

(a) First article inspection (see 4.3).
(b) Quality conformance inspection (see 4.4).

4.3 First article inspection. First article inspection shall be performed on a complete hasp style when a first article sample is required (see 3.2, 6.2 and 6.4). This inspection shall include the examination of 4.7 and the tests of 4.8 and 4.9. The first article shall be representative of the design, construction, and manufacturing technique applicable to the remaining hasps of the style to be furnished under the contract.

4.4 Quality conformance inspection. The quality conformance inspection shall consist of 100 percent visual inspection as specified in 4.7 and the tests specified in 4.8 and 4.9 performed on samples selected in accordance with 4.6.1.

4.5 Inspection lot. Units of the same style, manufactured in one production run, offered to the Government at one time, shall be considered a lot. The sample unit shall be one complete hasp style.

4.5.1 Weight of material. Hasps manufactured in one production run shall be weighed. In accordance with 3.3.1, total weight of hasps shall not exceed the weight of purchased certified metal.

4.6 Sampling. A random sample of hasps shall be selected from each lot in accordance with MIL-STD-105.

4.6.1 Sampling for tests. Tests for the hasp shall be based on inspection level S-4 of MIL-STD-105 and an acceptable quality level of 2.5 percent defective.

4.7 Examination. The first article, when furnished, and each hasp shall be examined for compliance with MIL-C-6021 and the requirements specified in section 3. Any redesign or modification of the contractor's standard product to comply with specified requirements, or any necessary redesign or modification following failure to meet specified requirements, shall receive particular attention for adequacy and suitability. This element of inspection shall encompass all visual examinations and dimensional measurements.

4.8 Tests. The first article, when required, and each sample hasp selected in accordance with 4.6.1 shall be tested to determine compliance with the specification. Tests shall be conducted as specified (see 4.8.1 and 6.4).

4.8.1 Hardness. Hardness tests shall be performed to determine compliance with 3.4.1.

4.9 Liquid penetrant inspection. Castings shall be examined by means of fluorescent liquid penetrant inspection in accordance with MIL-I-6866 using acceptance criteria of SAE AS 3071A.

4.10 Inspection of packaging. Sample packages and packs, and the inspection of the preservation-packaging, packing and marking for shipment and storage shall be in accordance with the requirements of section 5 and the documents specified therein.

5. PACKAGING

(The preparation for delivery requirements specified herein apply only for direct Government acquisition. For the extent of applicability of the preparation for delivery requirements of referenced documents listed in section 2, see 6.5.)

5.1 Preservation and packaging. The preservation and packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Unit packaging. Each hasp shall be unit packaged in a folding or setup paperboard box conforming to variety, style, type and class optional of PPP-B-566 or PPP-B-676. The contents shall be cushioned to prevent movement inside the container. Installation instructions shall be placed in a sealed paper or plastic envelope and packaged in the same box as the hasp. Each box shall be closed in accordance with the appendix to the applicable box specification.

5.1.2 Level C. Each complete hasp shall be preserved and packaged in accordance with the contractor's standard practice. Installation instructions shall be placed in a sealed paper envelope and packaged in the same box as the hasp.

5.2 Packing. Packing shall be level A, B, or C as specified (see 6.2).

5.2.1 Level A packing. Hasps of one style only, preserved and packaged as specified in 5.1, shall be packed in a snug-fitting cleated plywood or nailed wood shipping container conforming to overseas type of PPP-B-601, or class 2, style 2 or 4 of PPP-B-621. Each shipping container shall be provided with a type I or II, grade C case liner conforming to MIL-L-10547. Closure and strapping shall be in accordance with the appendix of the applicable container specification. Gross weight of each shipping container shall not exceed 200 pounds.

5.2.2 Level B packing. Hasps of one style only, preserved and packaged as specified in 5.1, shall be packed as specified in 5.2.1, except that the shipping container shall conform to domestic type, style A or B of PPP-B-601, or class 1, style 2 or 4 of PPP-B-621, and a case liner shall not be required.

5.2.3 Level C packing. Hasps, preserved and packaged as specified in 5.1, shall be packed in a manner to ensure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with Uniform Freight Classification or National Motor Freight Classification, as applicable.

5.3 Marking. In addition to any special marking required in the contract, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. This specification covers high security hasps of six basic styles for use with high security padlocks (Sargent and Greenleaf Model 831B, or equal), medium security padlocks conforming to MIL-P-43951 (Sargent and Greenleaf Model 826C, or equal), and the Navy produced dual control padlock.

6.2 Ordering data. Acquisition documents should specify the following:

(a) Title, number, and date of this specification.
(b) Title, number, and date of specification sheets (see 1.2).
(c) When a first article is required for inspection and approval (see 3.2 and 4.3).
(d) If other identification marking is required (see 3.7).
(e) Level of preservation and packaging and level of packing required (see 5.1 and 5.2).

6.3 First article inspection. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection as to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract.

6.4 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of FAR 52.209-4. The first article should be a preproduction sample, initial production item, or other specific item described under the definition of a first article in the FAR. The contracting officer should include specific instructions in all acquisitions regarding arrangements for inspection and approval of the first article.

6.5 Sub-contracted material and parts. The preparation for delivery requirements of referenced documents listed in section 2 do not apply when material and parts are acquired by the contractor for incorporation into the equipment and lose their separate identity when the equipment is shipped.

Preparing activity:
Navy - SH
(Project 5340-N078)

NOTES:
1. MATL. TO BE 304 L FOR ITEMS 1,2,3,4,6,7A,7B & 9.

2. INVESTMENT CASTING/MIL-C-6021E CL-2B OF CERTIFIED ALLOYS.
3. "ZYGLO" INSPECTION PER I6M66.

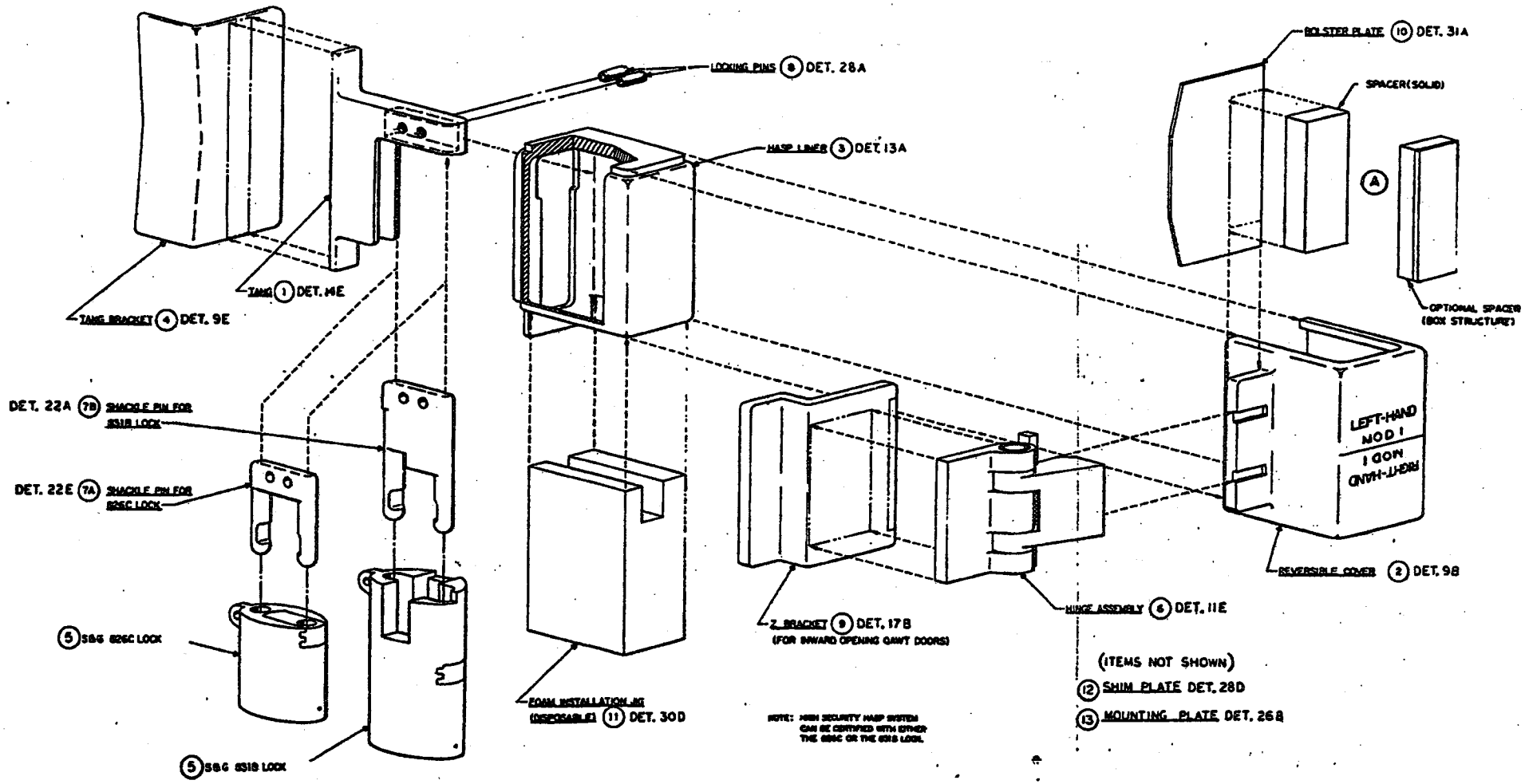
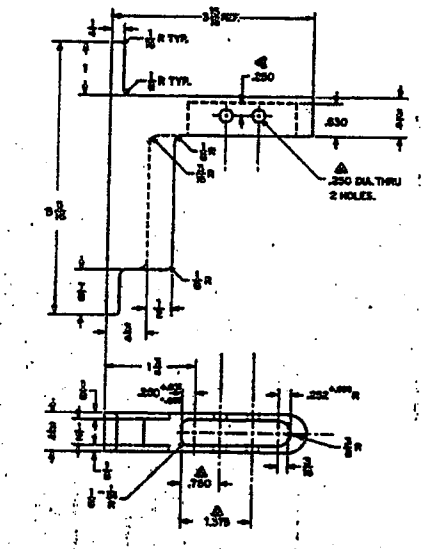


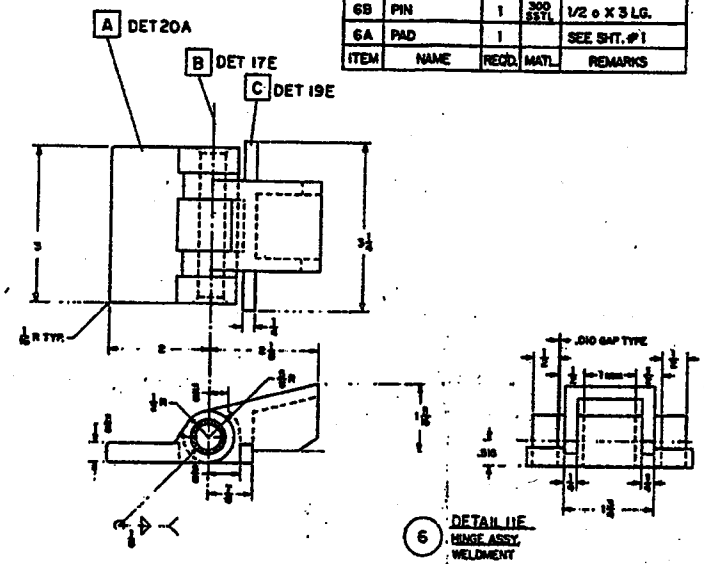
FIGURE 1. High security hasp, shipboard configuration and parts list.



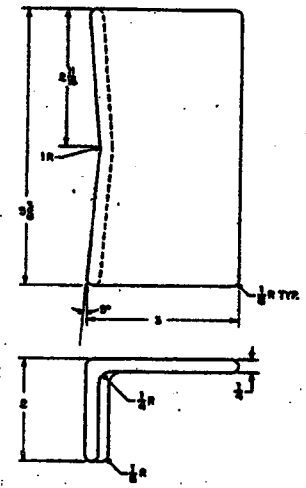
⚠ DIMS. MUST MATCH 7A & 7B TO ALLOW ASSY. USING (2) ROLL PINS.

1 DETAIL 14E
TANG
MATL. 304 L
NO. REQD: 1 PER STYLE

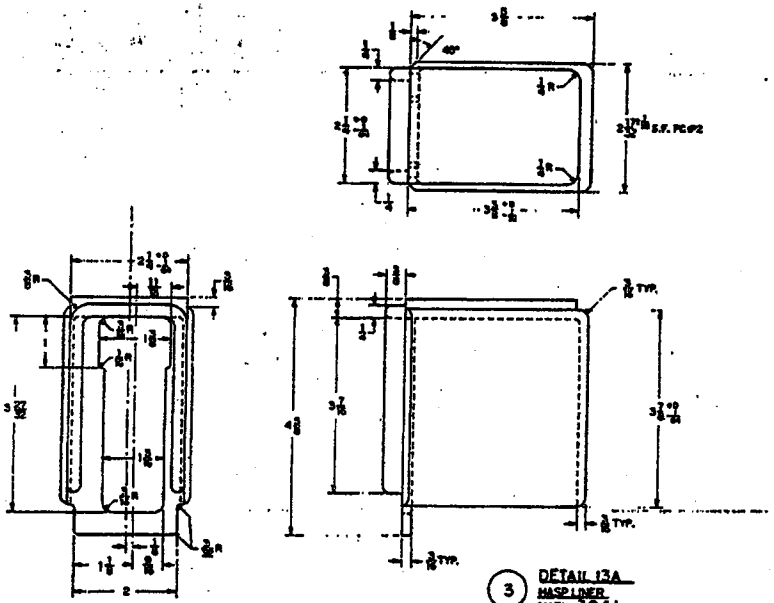
ITEM	NAME	REQD.	MATL.	REMARKS
6C	BRACKET	1		SEE SHT. #1
6B	PIN	1	300 SSTL	1/2 ø X 3 LG.
6A	PAD	1		SEE SHT. #1



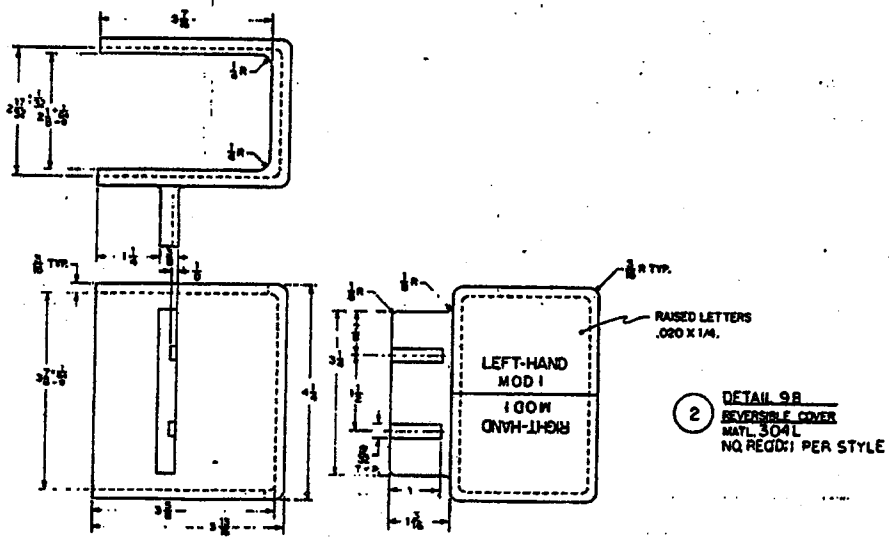
6 DETAIL 11E
HINGE ASSY, WELDMENT
DETAILS ON SHEET 3
NO. REQD: 1 PER APPL. STYLE



4 DETAIL 9E
TANG BRACKET
MATL. 304L
NO. REQD: 1 PER APPL. STYLE

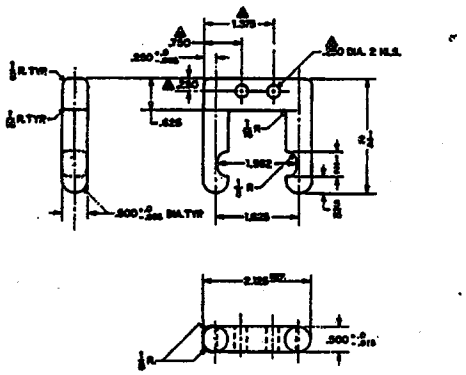


3 DETAIL 13A
HASP LINER
MATL. 304 L
NO. REQD: 1 PER STYLE



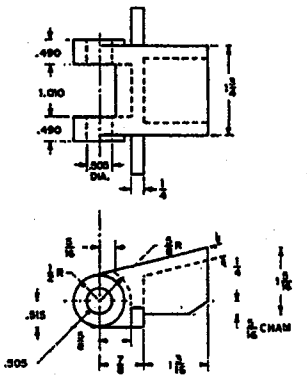
2 DETAIL 9B
REVERSIBLE COVER
MATL. 304L
NO. REQD: 1 PER STYLE

FIGURE 1. High security hasp, shipboard configuration and parts list. - Continued

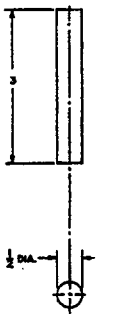


▲ SEE NOTE PC#1

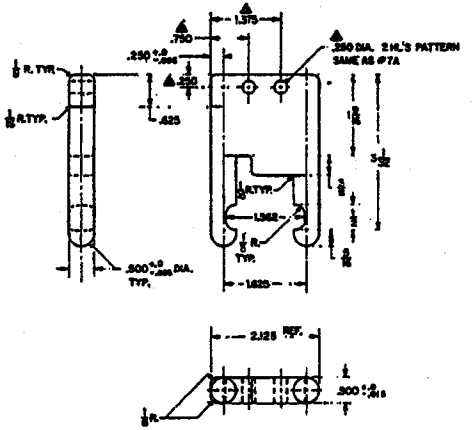
7A DETAIL 22E
SHACKLE PIN FOR
826-C LOCK/ 1/2 ø
SHACKLE REMOVED
MATL. 304L
NO. REQD: 1 PER STYLE



6C DETAIL 19E
HINGE BRACKET
MATL. 304L

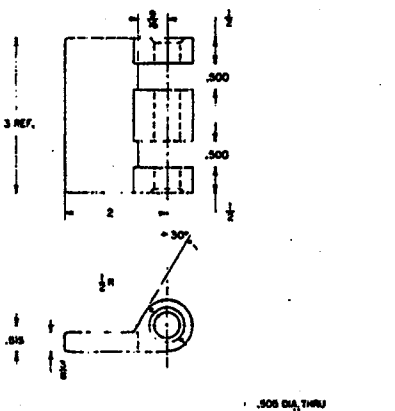


6B DETAIL 17E
PIN
MATL. 300SSTL

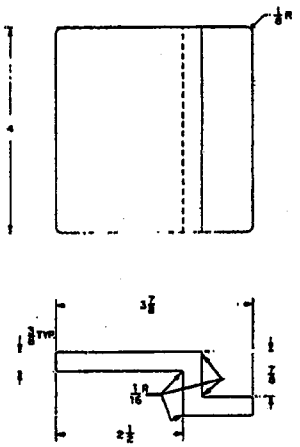


▲ SEE NOTE PC#1

7B DETAIL 22A
SHACKLE PIN FOR
831-B WITH 1/2 ø
SHACKLE REMOVED
MATL. 304L
NO. REQD: 2 PER STYLE

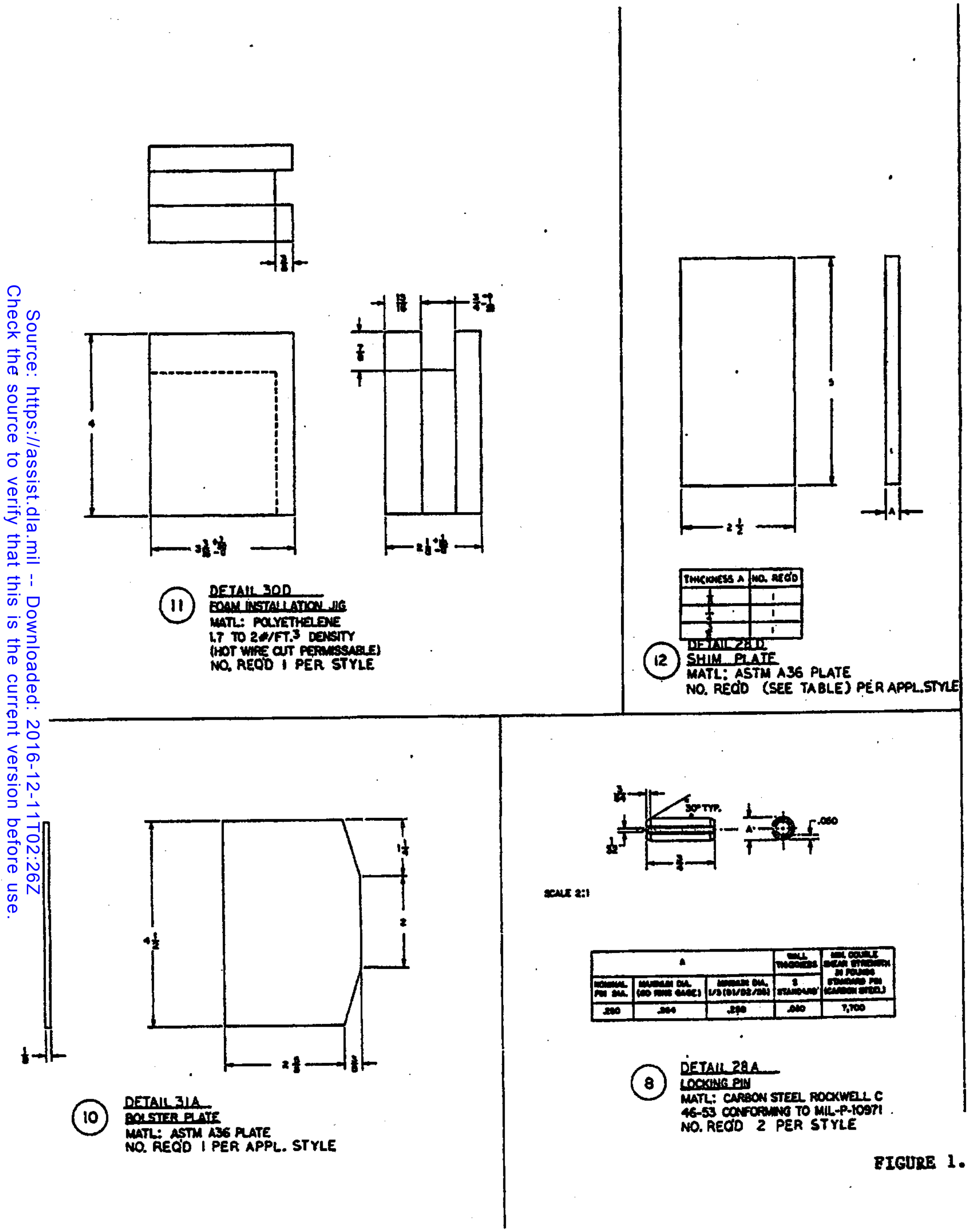


6A DETAIL 20A
HINGE PAD
MATL. 304L



9 DETAIL 17B
"Z" BRACKET FOR
INWARD OPENING
CAWT DOORS
MATL. 304L
NO. REQ'D: 1 PER APPL. STYLE

FIGURE 1. High security hasp, shipboard configuration and parts list. - Continued



THICKNESS A	NO. REQ'D
[illegible]	1
[illegible]	1
[illegible]	1

A			WALL THICKNESS	MIN. DOUBLE SHEAR STRENGTH IN POUNDS STANDARD PIN (CARBON STEEL)
NOMINAL PIN DIA.	MAXIMUM DIA. (GO RING GAGE)	MINIMUM DIA. 1/3 (D1/D2/D3)	S STANDARD	
.250	.264	.258	.040	7,100

FIGURE 1. High security hasp, shipboard configuration and parts list. - Continued